

Work Order ID 83383

83383

Page 1

Tuesday, April 17, 2012 3:19:32 PM

Item ID: D4153-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Joggle Bracket
 Start Date: 4/17/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 4/30/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-04-17 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4153	B								

110 0.00
110
 Waterjet Memo 0.00
 FLOW CNC Waterjet CUT AS DWG
 304 0.050 DWG REV: B
 PROG REV: B
 DEBURR
 120 0.00
120
 QC Memo 0.00
 Quality Control
 6 0 Jm/12/11
 12-4-29
 6 0 Jm/12/11
 12-4-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4153-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Joggle Bracket

Start Date: 4/17/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/30/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(X6)			
140 *140* Brake NC Brake NC	Form as per dwg Memo	0.00 0.00				5	1		
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(X5)	(X1)		

PTD
Sh 2/10/12

W/O: 83383		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4153-3 PAR #: _____ Fault Category: Small FAB NCR: Yes No DQA: AK Date: 12/05/14
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: CL Date: 12/5/14

NCR: 12-1416		WORK ORDER NON-CONFORMANCE (NCR) 34.05						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/14	130	1 part at the set up was out of tolerance R-c process	S 12/05/14 067042	Scrap + destroy Qty +1 no Replace.	S 12/05/14	S 12/05/14 067042	S 12/05/14 067042	S 12/05/14

NOTE: Date & initial all entries

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Item ID: D4153-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Joggle Bracket

Start Date: 4/17/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/30/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: **241A**

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/5/8**11205-8**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 83383

83383

Parent Item: D4153-3

D4153-3

Parent Item Name: Joggle Bracket

Start Date: 4/17/2012

Required Date: 4/30/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.09.26 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			110	sf	37.4860	0.963	6.082105			

M304S18GA

304/316 .050 Sheet

**

Location	Loc Qty	Loc Code
MAT020	33	
120604	33	
MAT20	4.486	
121192	4.486	

119188

16.1

119188
16.1

Sum/AM
12-4-29

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

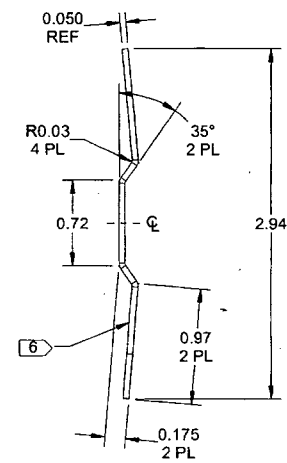
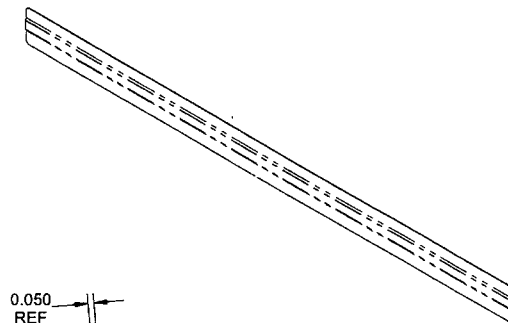
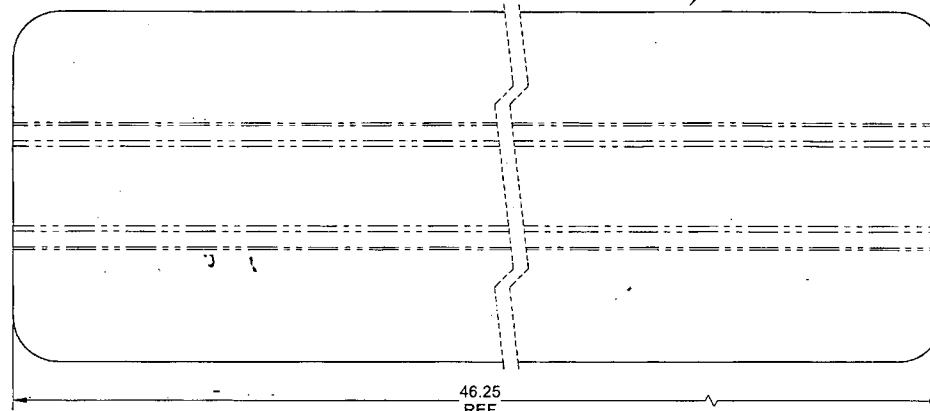
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83383

R1204-17



D4153-3 JOGGLE BRACKET
(MAKE FROM D4153-3F FLAT PATTERN)



RELEASED
2011-09-21
JW

NOTES:

- 1) MATERIAL: MAKE FROM D4153-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1, ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WEIGHT: 1.99 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4153	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	JOGGLE BRACKET	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

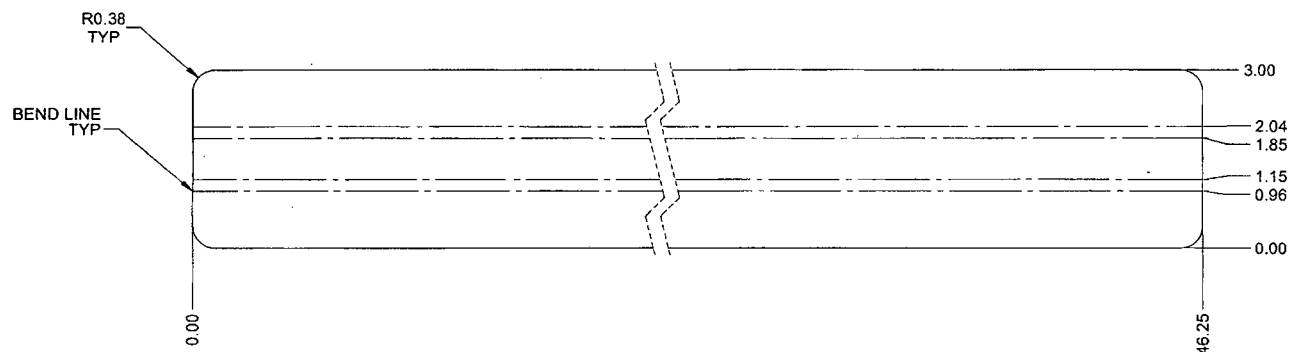
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NOTE: Date & initial all entries



D4153-3F FLAT PATTERN

73383

RELEASED
2011-09-21
NW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 18 GAUGE (0.050 THICK)
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.98 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4153	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	JOGGLE BRACKET	NTS
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